

**Work Order ID 67048**

Page 1

Friday, March 04, 2011 11:21:09 AM

Item ID: D412-698-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Cabin Door Roller, LH

Start Date: 3/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/8/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN D412-698

Rev E

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-698-011 CHG003

8 u103/14

HJ for CL 11-3-9

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

11/3/14 SP (12)

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

8 u103/14

(X)

**Work Order ID 67048**

Friday, March 04, 2011 11:21:09 AM



Page 2

Item ID: D412-698-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Cabin Door Roller, LH

Start Date: 3/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/8/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging	Packaging	0.00							
Packaging	<b>Memo</b> Identify and pack for shipping as per PPP D412-698-011 Location: <u>62</u>	0.00 <i>Reob</i>							<i>11/3/14</i> <i>SP/D</i>
140  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	<b>Memo</b>	0.00							<i>11/3/15</i> <i>MF</i> <i>11-03-14</i>

Friday, March 04, 2011 11:21:06 AM

Page 1

**Parent Item:** D412-698-011

**Parent Item Name:** Cabin Door Roller, LH





**Start Date:** 3/4/2011

**Required Date:** 3/8/2011

**Start Qty: 1.00**

**Required Qty: 1.00**

**Comments:** IPP Rev:C 04.02.26 Change Qty of D3121-141 & remove D3121-145 from Step 1,3 KJ/DS  
IPP Rev:D 08-01-28 change to rev D ECN 1104 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3121-141  Bracket Assembly		Manufactured	No			100	Each	6.0000	3	3		11/3/14	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST235A				6					
				61832				6					
D3121-143  Bracket Assembly		Manufactured	No			110	Each	10.0000	1	1		11/3/14	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST235A				10					
				61340				2					
				61406				8					
D3183-043  Bracket Assembly		Manufactured	No			110	Each	6.0000	1	1		11/3/14	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST236				6					
				62001				6					
D3137-043  Bracket Assembly		Manufactured	No			110	Each	5.0000	1	1		11/3/14	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST235B				5					
				62831				5					

# Picklist Print

Page 2

Friday, March 04, 2011 11:21:06 AM

Work Order ID: 67048

Parent Item: D412-698-011

Parent Item Name: Cabin Door Roller, LH

Start Date: 3/4/2011

Required Date: 3/8/2011

Start Qty: 1.00

Required Qty: 1.00

D3199-1

Manufactured No

110

Each

56.0000

9

9



Bracket



11/3/14 SP

## Location

## Loc Qty

## Loc Code

ST236A

56

61484

56

9

Manufactured No

110

Each

16.0000

D3202-1



Cover



11/3/14 SP

(12)

## Location

## Loc Qty

## Loc Code

ST241A

16

59693

6

66252

10

1

Friday, March 04, 2011 11:21:07 AM

Shop Packet Print

Page 2

**6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS**

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Part Number	Description
X						D412-698-011	CABIN DOOR ROLLER KIT, LH
	X					D412-698-012	CABIN DOOR ROLLER KIT, RH
		X				D412-698-013	DOOR HANDLE KIT
			X			D412-698-017	REPLACEMENT DOOR TRACK KIT
				X		D412-698-019	BEARING OVERHAUL KIT
					X	D412-698-021	REPLACEMENT SHIM KIT
<del>3</del>	<del>3</del>					<del>D3121-141</del>	BRACKET ASSEMBLY
<del>1</del>						<del>D3121-143</del>	BRACKET ASSEMBLY
	<del>1</del>					<del>D3121-144</del>	BRACKET ASSEMBLY
<del>1</del>	1					<del>D3137-043</del>	BRACKET ASSEMBLY
<del>1</del>						<del>D3183-043</del>	BRACKET ASSEMBLY
	1					<del>D3183-044</del>	BRACKET ASSEMBLY
<del>9</del>	<del>9</del>		<del>9</del>			<del>D3199-1</del>	BRACKET
<del>1</del>	<del>1</del>		<del>1</del>			<del>D3202-1</del>	COVER
		4				D3203-1	HANDLE
		1				D3220-041	DOUBLER
		1				D3220-042	DOUBLER
		2				D3220-3	DOUBLER
				7		D3121-21	BOLT
				5		D3121-241	BEARING ASSEMBLY
				1		D3137-3	GUIDE
				1		D3137-5	WASHER
				2		D3183-045	BEARING ASSEMBLY
					3	D3238-1	SHIM
					1	D3238-3	SHIM
					2	D3238-5	SHIM
					6	D3238-11	SHIM
					2	D3238-13	SHIM
					4	D3238-15	SHIM
		8				AN960JD416L	WASHER
		8				MS21042L4	NUT (OR MS21042-4)
		16				MS24694-S98	SCREW
				1		MS24694-S101	SCREW

• COPYRIGHT © 2003 BY DART AEROSPACE LTD •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: E

Date: 08.05.01